

# Work Order ID 72226

Wednesday, July 20, 2011 8:59:56 AM



Page 1

Item ID: D6101-003

Revision ID:

Item Name: Saddle Billet, 7075

Start Date: 7/20/2011 Start Qty: 40.00

Required Date: 8/3/2011 Req'd Qty: 40.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan: *CZ*

QC:

Date: 11/07/20 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O:

*14554*

a) Description: Alluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

*CZ 11/07/21*

*(90)*

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure material certification is attached

*Packaging*

*(50)*

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Wednesday, July 20, 2011 8:59:56 AM



Page 2

Item ID: D6101-003

Accept



Setup Start



Revision ID:

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Stop



Start Date: 7/20/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

*anf 11/08/11*

*20 0*

130

Identify as per dwg & Stock Location: *MAT44* 0.00



Packaging

Memo

0.00

Packaging

*anf 11/08/11*

*20 0*

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*CK 11/08/11*

*M 11-08-11  
(20)*

# Picklist Print

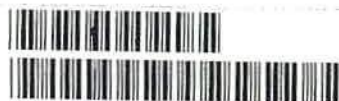
Wednesday, July 20, 2011 8:59:54 AM

Page 1

Work Order ID: 72226

Parent Item: D6101-003

Parent Item Name: Saddle Billet, 7075



Start Date: 7/20/2011

Required Date: 8/3/2011

Start Qty: 40.00

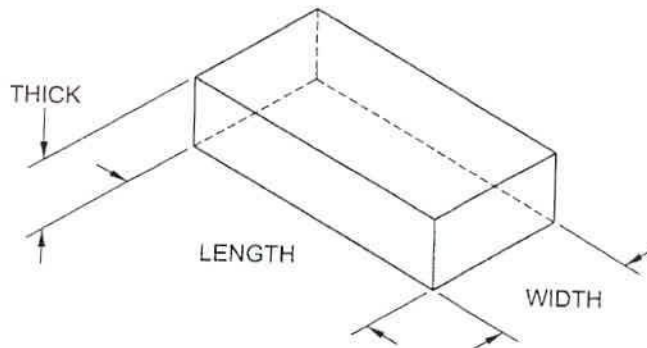
Required Qty: 40.00

Comments: IPP A: 101.05.04 (New Issue) IEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P		Purchased	No			110	Each	0.0000	1	40			
7075-T7351 2X6.25X7.875													

*4/18/9 (20)*

# SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

**B** ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

**RELEASED**  
09/07/15/W

*CL 11/07/20  
W10.72226*

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**Castle Metals®**

A. M. Castle &amp; Co.

## PACKING SLIP

Page 1 of 1

Shipment No:926568

<b>Ship From:</b> A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b> 08-AUG-2011	<b>F.O.B.</b> ORIGIN	<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN		<b>BOL No</b> 926568-2	

<b>Shipment Details</b>				<b>Final Destination Branch - MON</b>			
<b>Order No</b> 1604804	<b>Line No</b> 1	<b>Item No</b> 752237.MO	<b>Description</b> 2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
<b>Purchase Order No</b> 14554		<b>Part Number</b> YOUR ITEM NUMBER: D6101-003		<b>Ordered Qty</b> 20 PCS		<b>Invoice Qty</b> 20 PCS	
<b>Details</b>							
<b>Delivery No.</b> 88620338	<b>Mill</b>	<b>Heat Number</b> 589281	<b>Mech Id</b>	<b>PCS</b> 20	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty(LBS)</b> 203.22

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:	Date:
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# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

*Kenton P. Young*

Malcolm Murphy  
Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

1053732  
Ship Date 0 B.L. No. Invoice No. Alcoa No. Item Page  
2009-10-05 4263345 00000 1000138763-1 DS-38763-1  
P.O. No./Govt Contract No. Customer Alcoa Item  
01-23065 Ln#: 1 CASTLE METALS G041C03428R14

Ship To: A M CASTLE & COMPANY  
3400 NORTH WOLF ROAD  
BAY #6  
FRANKLIN PARK 60131 IL

Item Description  
2.0 IN TX (+.055 -.055) X 48.5 IN W (+.3125 -  
0.000) X 144.5 IN LN (+.5 -.00) CAT D 164164 (N) A/T 7075-  
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,  
SAND IAC 6857. EXC MRK A97075-60 REV 25 AMS-QQ-A-250/12 IS 2007 AMS-  
STD-2154 EXC MRK AMS4078 REV G EXC MRK ASTMB209  
REV 07 ASTMB594 REV 06 BSS7055 REV A  
EXC MRK MMS159 REV N PS21211 REV K ((MARKED))  
KRAFT PAPER INTERLEAVED  
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-  
40 % US1 CL A 3 MM CQR 0107687 REV 32 CUST REQ 09-10-  
05 \*\*\* W/E 09-10-10 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector Clock Numbers
1	759983	589281	2842	2	PC	:	47091
2	759987	589261	2848	2	PC	:	47091
3	759988	589291	2870	2	PC	:	47091
			8560	6			

Notes for CQR: 0107687.32  
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE  
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.  
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMME RSION - TYPE I.  
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMME RSION - TYPE I.  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12P. PROD UCT  
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.  
Exception to Spec A97075-60 ; Revsn: 25 Issue: Letter dated 2008-12-11 from TUCKER, BONNIE to PLATTER, R.  
CQR: 0107687.32 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
T7351	Long Transv.	KSI	KSI	PCT
		Max	63.9	
		Min	69.0	57.0
T7351	Elec. Cond. (EC) % MIN	38.0	PCT	6

8474558824

10-12-'09 08:40 FROM-AM Castle

T-262 P018/038 F-117

17041